

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002045**Date Inspected:** 30-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Hui Zhen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the San Francisco/Oakland Bay Bridge.

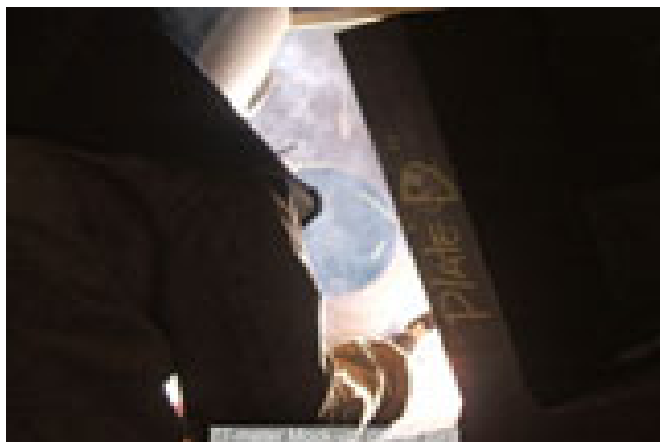
77-meter Mock-Up, Z. P. M. C., Welder, Xu Wei--266253, welded on weld number MUA-MA1-E/F-2. The QA Inspector checked the amperage and recorded, at different time intervals, 202 amps and 193 amps.

89-meter Mock-Up, Z. P. M. C., Welder Dai Lu--048659 and Wang Zhonghua--053752, tack welded Skin A to the diaphragm. Welding Procedure Specification (WPS)-B-T-4312-TC-P5-1, was used to weld this. The QA Inspector checked the welding parameters and recorded 192 amps and 186 amps respectively, at different time intervals. Z. P. M. C. personnel started fitting Skin E to the diaphragm.

114-meter Mock-Up(upper), Z. P. M. C., Welder, Yun Chuanjin--0503060, using WPS-B-T-2221-C-U2b-S, started welding MUC-MA111. The QA Inspector checked the welding parameters and recorded 738 amps and 32.2 volts, this is a Submerged Arc Welded joint. Z. P. M. C., Welder, Dai Lu--048659, started tack welding Skin A to the Diaphragm, using WPS-B-T-Tc-P5-1. QA measured the amperage and recorded 192 amps.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No substantial conversations took place.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|--------------|-----------------------------|
| Inspected By: | Stovall,Paul | Quality Assurance Inspector |
| Reviewed By: | Cochran,Jim | QA Reviewer |
